

Work Order ID 62555

Page 1

Monday, October 04, 2010 10:58:30 AM

Item ID: D350-589-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Side Door Latch Modification

Start Date: 10/4/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 10/20/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

H

Date: 10-10-04

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
INN-D350-589	E								
100		0.00							
	DOCUMENT CONTROL								
DC	Memo	0.00							
Document Control	Photocopy blue file and type label as per PPP D350-589-011 CHG002								
105		0.00							
	Pick Kit								
Packaging	Memo	0.00							
Packaging									
110		0.00							
	QC4- 100% Inspect kits for completeness								
QC	Memo	0.00							
Quality Control									

8/10/10/25

H for BG 10-10-22
②

8/10/10/25 ②

8/10/10/25

②

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval, QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, October 04, 2010 10:58:34 AM

Page 1

Work Order ID: 62555

Parent Item: D350-589-011

Parent Item Name: Side Door Latch Modification

Start Date: 10/4/2010

Required Date: 10/20/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP F02.08.29 Removed D2587 Plug KJ
ALL AT CHANGE 002

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN960JD10 NAS1149D0363J Purchased No

105

Each

8.0000

3

6



Washer

Location

Loc Qty

Loc Code

ST

6

107715

6

ST335

2

105792

2

Manufactured

No

105

Each

25.0000

3

6

D2237



Striker Plate

Location

Loc Qty

Loc Code

ST009

25

58181

3

60492

22

Manufactured

No

105

Each

30.0000

3

6

D2583



Latch Bracket

Location

Loc Qty

Loc Code

ST017

28

60497

4

61715

24

ST018

2

56527

2

11/15/22

6

60492

6

61715

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, October 04, 2010 10:58:34 AM

Page 2

Work Order ID: 62555

Parent Item: D350-589-011

Parent Item Name: Side Door Latch Modification

Start Date: 10/4/2010

Required Date: 10/20/2010

Start Qty: 2.00

Required Qty: 2.00

D2585
Mounting Channel

Manufactured No

105 Each

38.0000

3

16

Location

Loc Qty

Loc Code

ST019

38

56524

1

59118

11

59873

26

56524
59118
59873
6

D2586
Door Latch

Manufactured No

105 Each

76.0000

3

6

Location

Loc Qty

Loc Code

ST006

16

57917

16

ST204

60

61655

60

57917
61655
6

D2587
Door Slug, 350 Hinge

Manufactured No

105 Each

20.0000

1

2

Location

Loc Qty

Loc Code

ST019

20

56555

20

56555
2

D2589
Keys, Key Chain, 350 Hinge

Manufactured No

105 Each

173.0000

1

2

Location

Loc Qty

Loc Code

ST019

173

58194

173

58194

Monday, October 04, 2010 10:58:34 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, October 04, 2010 10:58:34 AM

Page 3

Work Order ID: 62555

Parent Item: D350-589-011

Parent Item Name: Side Door Latch Modification

Start Date: 10/4/2010

Required Date: 10/20/2010

Start Qty: 2.00

Required Qty: 2.00

MS20470AD4-5

Purchased

No

105

Each

941.0000

6

12



Rivet, Universal Head

Location

Loc Qty

Loc Code

ST309

876

114761

876

ST319

65

111916

65

MS21042L3

Purchased

No

105

Each

1,720.000

3



Nut

Location

Loc Qty

Loc Code

ST300

1720

114523

49

114784

1671

MS27039-1-15

Purchased

No

105

Each

67.0000

3



Screw

Location

Loc Qty

Loc Code

ST292

67

114056

2

114718

65

11/4761

1/6

11/4784

1/6

11/4718

Monday, October 04, 2010 10:58:34 AM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

52.4 PARTS LIST

589 -011	589 -041	589 -042	589 -043	Part Number	Description
X				D350-589-011	SIDE DOOR LATCH MODIFICATION KIT
	X			D350-589-041	SIDE DOOR ASSEMBLY, LH AS 350
		X		D350-589-042	SIDE DOOR ASSEMBLY, RH AS 350/355
			X	D355-589-043	SIDE DOOR ASSEMBLY, LH AS 355
	1			D2991-1	Door
		1		D2991-2	Door
			1	D2991-3	Door
3	3	3	3	D2237 /	Striker Plate
	1	1	1	D2464-1700 /	Seal
3				D2583	Latch Bracket
3	3	3	3	D2585	Latch Clamp
3	3	3	3	D2586 /	Latch
1				D2587 /	Plug
1	1	1	1	D2589 /	Keys, Key Chain
	3	3	3	D2621	Latch Plate
	2**	2**	2**	D2992-1	Doubler
	1	1	1	D3085-041	Prop Assembly
	1*	1*	1*	D3015-3	Locknut
	1*	1*	1*	D3081-1	Prop Hinge
	1*	1*	1*	D3082-1	Clip
	1*	1*	1*	D3084-1	Prop Arm
	1*	1*	1*	AN4-5A	Bolt
	3*	3*	3*	AN960JD10	Washer
	3*	3*	3*	AN960JD10L	Washer
	2*	2*	2*	AN960JD416	Washer
	1*	1*	1*	AN960JD516L	Washer
	3*	3*	3*	MS21042L3	Nut (or MS21042-3)
	1*	1*	1*	MS21042L4	Nut (or MS21042-4)
	3*	3*	3*	MS27039-1-13	Screw
	1*	1*	1*	SL69-BS	Ball Stud
	6	6	6	AN3-4A	Bolt
3	3	3	3	AN960JD10	Washer
3	9	9	9	MS21042L3	Nut (or MS21042-3)
6	6	6	6	MS20470AD4-5	Rivet
3	3	3	3	MS27039-1-15	Screw

* Reference only. Included in D3085-041 Prop Assembly listed above.

** Reference only. Included in D2991-1/-2/-3 Doors listed above.

• COPYRIGHT © 2002 BY DART AEROSPACE LTD. •

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

52-00-00